



Certificate of Conformance to Requirements for Welding Electrode

Product Type: FabCO 410 NiMoT1
Classification: E410NiMoT1-4/-1 (H4)
Specifications: AWS A5.22/A5.22M; ASME SFA 5.22
Diameter Tested: 1/16"
Date Tested: 1/5/2021
Date Generated: 3/12/2021

This is to certify that the product named above and supplied on the referenced order number is of the same classification, manufacturing process, and material requirements as the material which was used for the test that was concluded on the date shown, the results of which are shown below. All tests required by the specifications shown for classification were performed at that time and the material tested met all requirements. It was manufactured and supplied by the Quality System Program of Hobart Brothers, which meets the requirements of ISO 9001, ANSI/AWS A5.01, and other specification and Military requirements, as applicable. This document supplies actual test results of non-specific inspection in conformance with the requirements of EN 10204, type 2.2 certification.

Test Settings

Shielding Medium	Amps / Polarity	Volts	WFS in/min(m/min)	ESO in(mm)	Preheat F(C)	Interpass F(C)	Travel Speed in/min(cm/min)
C1 (100% CO2)	250 / DCEP	28	250 (6.4)	3/4 (19)	400(204)	500(260)	10 (25.4)
M21-ArC-25	250 / DCEP	28	255 (6.5)	3/4 (19)	400(204)	500(260)	10 (25.4)

Mechanical Properties - Tensile

Shielding Medium	Ref. No.	Testing Conditions	Ult. Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elong.% in 2"
C1 (100% CO2)	PE1692	SR 1 Hr @ 1125F	130,000 (896)	115,000 (793)	16
M21-ArC-25	PE1695	SR 1 Hr @ 1125F	130,000 (896)	122,000 (841)	15

Ref.No.	Radiographic Inspection	Fillet Weld Test			
PE1692	Conforms	Horizontal :	Overhead :	Conforms	Vertical : Conforms
PE1695	Conforms	Horizontal :	Overhead :		Vertical :

Chemical Analysis

Shielding Medium / Ref. No	CombC	Mn	P	S	Si	Cu	Cr	V	Ni	Mo	Al	Ti	Nb	Co	B	W	Sn	Fe	Sb	N	Mg	Zn	Be	Sb	As
C1 (100% CO2) / PE1692		0.31	0.009	0.007	0.31	0.04	12.0		4.6	0.60															
M21-ArC-25 / PE1695		0.35	0.008	0.007	0.38	0.04	12.2		4.5	0.59															

Diffusible Hydrogen Collected per AWS A4.3

C1 (100% CO2)	1.4 ml/100g of weld metal for 1/16 in diameter 49% relative humidity
M21-ArC-25	2.5 ml/100g of weld metal for 1/16 in diameter 48% relative humidity

Dave Thomas

Dave Thomas, Quality Assurance Rep.

Certification and Limited Warranty - Data for the above supplied product are those obtained when welded and tested in accordance with the above specification. All tests for the above classification were satisfied. Other tests and procedures may produce different results.